

511

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 22411
<b>Description:</b> Lug and Bracket	<b>Part Number:</b> <del>D3016-13-15-17</del> D3017-7
<b>Dwg:</b> D3016 Rev. A; D3017 Rev. A page 1	<b>Qty:</b> 30 <del>20</del> Kits
	Page 1 of 2

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Ticket To be made in multiples of 8.	PA	05.02.14	20
2	MV	Cut blanks: 1.53" x 1.50" (+/-0.010) Material: AISI 4130N Sheet, 0.049" thick (M4130N-S049) Identify for D3016-17			
3	MV	Cut blanks: 7.90" x 4.070" (+/-0.010) Material: AISI 4130N Sheet, 0.049" thick (M4130N-S049) Identify for D3016-13			
4	MV	Cut blanks: 2.580" x 2.580" (+0.010/-0.000) Material: AISI 4130N Sheet, 0.049" thick (M4130N-S049) Identify for D3016-15			
5	MV	Cut (12) D3017-7 blanks per 8 Kits Cut blanks: 4.200" x 3.180" (+/-0.010) Material: AISI 4130N Sheet, 0.049" thick (M4130N-S049) Identify for D3017-7			
6	MV	Machine D3016-15 as per Folio FA162 and Dwg D3016 Use Stack of 8 Identify as D3016-15			
7	QC2	Inspect parts as they come off the CNC machine			
8	MV	Deburr			
9	QC5	Second check			
10	MV	Machine D3016-13 as per Folio FA162 and Dwg D3016 Use Stack of 8 Identify as D3016-13			
11	QC2	Inspect parts as they come off the CNC machine			
12	MV	Deburr			
13	QC5	Second check			
14	MV	Machine D3017-7 as per Folio FA163 and Dwg D3017 Use Stack of 6 Identify as D3017-7			
15	QC2	Inspect parts as they come off the CNC machine			
16	MV	Deburr			
17	QC5	Second check			
18	GA	Grind D3016-17 radius as per Dwg D3016 Identify as D3016-17			
19	GA	Deburr			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

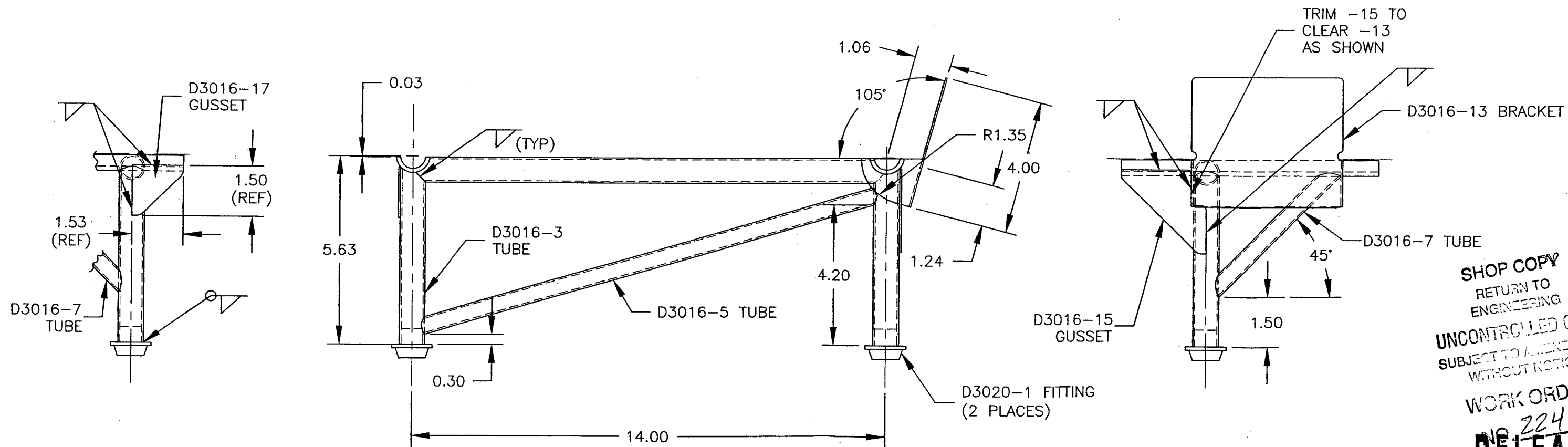
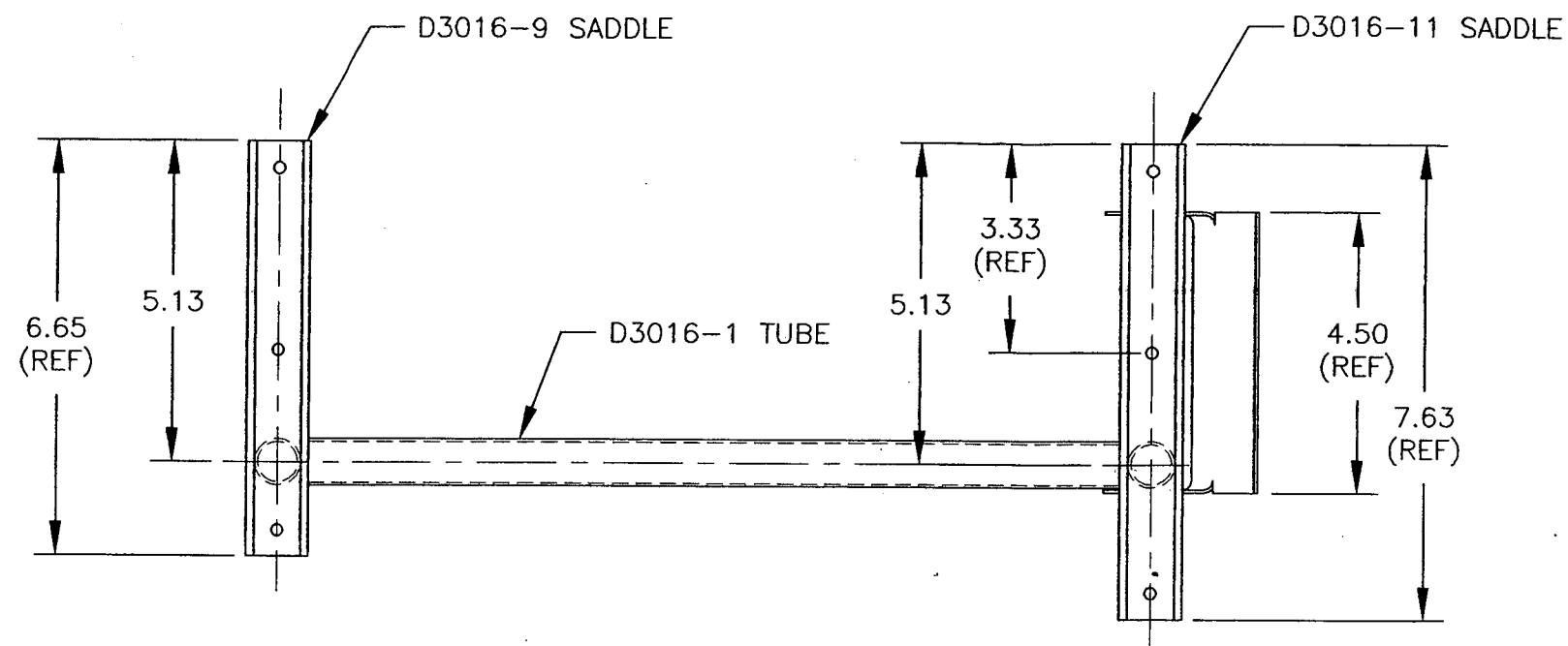
<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	22411
<b>Description:</b> Lug and Bracket	<b>Part Number:</b>	D3016-13/-15/-17
		D3017-7
<b>Dwg:</b> D3016 Rev. A; D3017 Rev. A page 1	<b>Qty:</b>	20 Kits
		Page 2 of 2

Step	Location	Procedure	By	Date	Qty
20	QC5	Inspect work to Step 19	MA	05/03/01	30
21	GB	Form D3017-7 as per Dwg D3017 and D3016-13 as per Dwg D3016	2	05.03.01	30
22	QC5	Inspect work to Step 21	MA	05/03/01	30
23	GA	Identify and bag with light oil (Vactra oil No. 2) D3016-13 Qty: <del>30</del> D3016-15 Qty: <del>30</del> D3016-17 Qty: <del>30</del> D3017-7 Qty: 30	MA	05/03/01	30
24	AC	Parts to Stock and prorate cost of parts per Step 23 Cost / part 29.04	SAC	05.03.02	30
25	DC	Close W/O 26.41 Inspect Level 21	MA	05.03.02	30

Rev	Date	Change	Revised By	Approved
A	01.09.11	New issue	EC	
B	03.05.09	Reformat	KJ/RF	RF

RELEASED  
03.06.11 RF

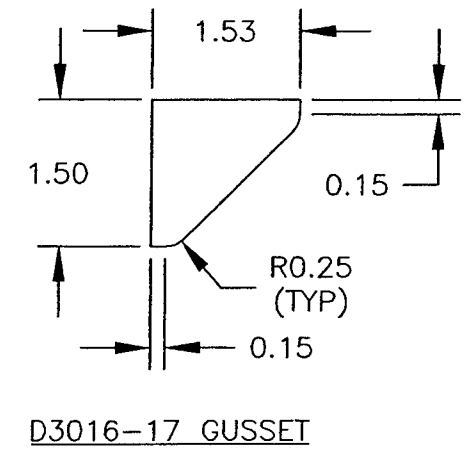
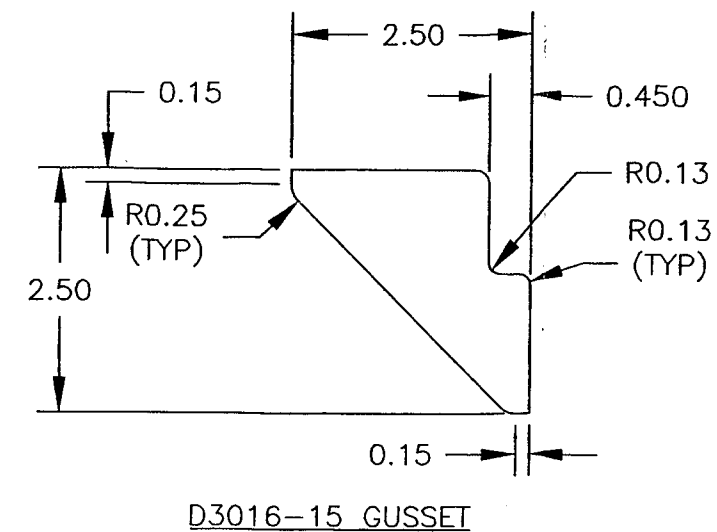
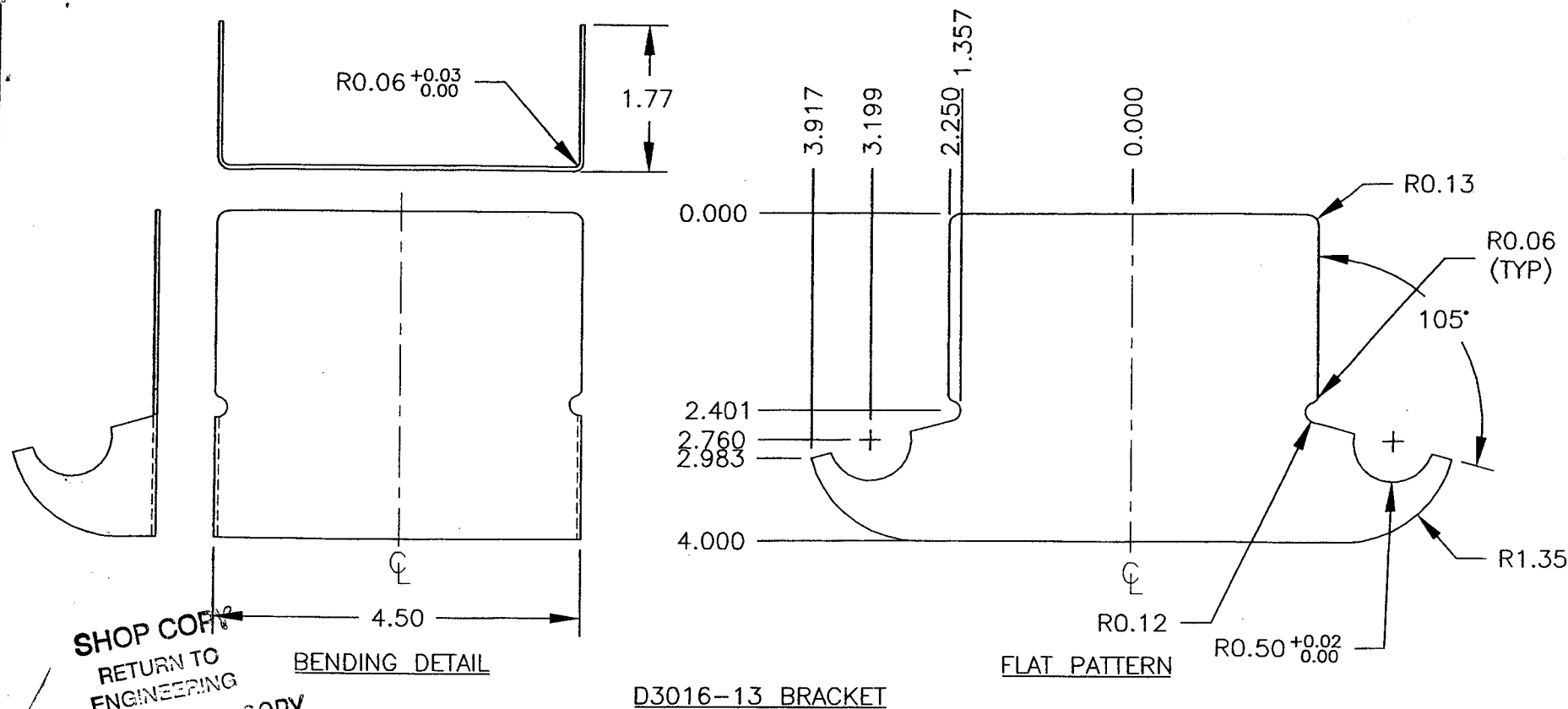
# D3016-041 SEAT FRAME ASSEMBLY



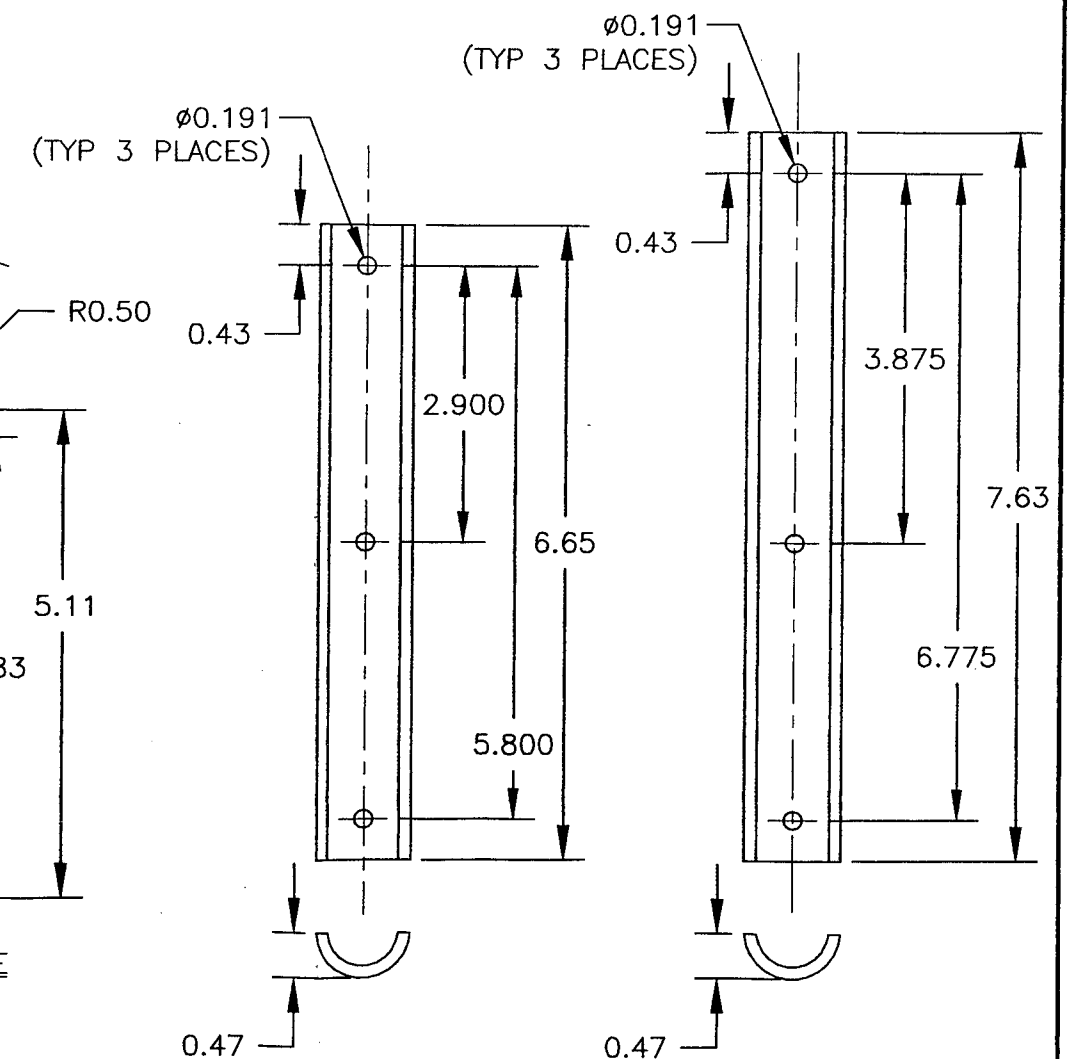
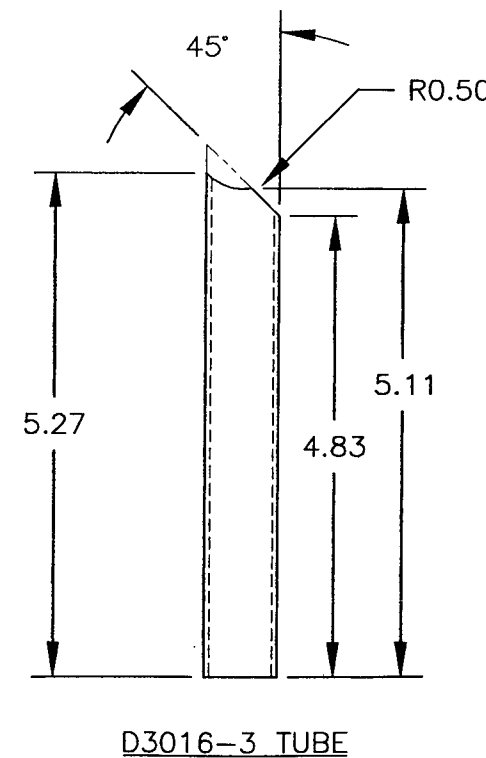
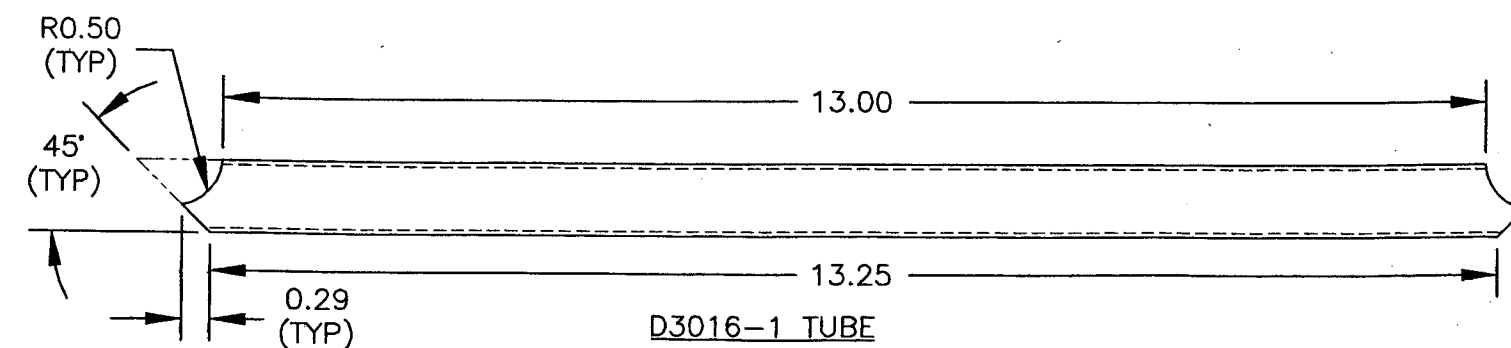
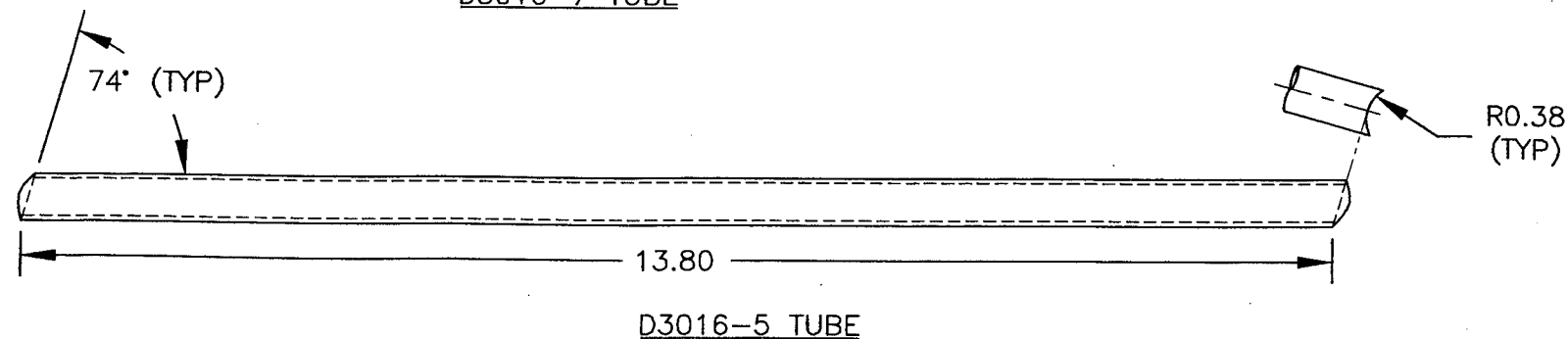
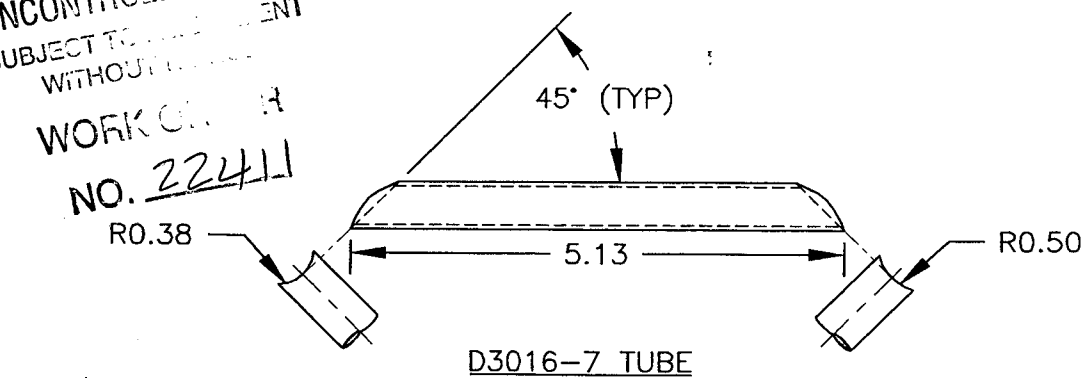
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DATE		01.05.18		DRAWING NO.	REV. A
				D3016	SHEET 2 OF 3
				TITLE	SCALE
				SEAT FRAME ASSEMBLY	1:3



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HAWKESBURY, ONTARIO, CANADA

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DRAWING NO.

D3016

REV. A

DATE

01.05.18

TITLE

SEAT FRAME ASSEMBLY

SCALE

1:2



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>A</i>	APPROVED <i>A</i>	DRAWING NO. D3017	REV. A SHEET 1 OF 2
DATE 01.05.18		TITLE BACK FRAME ASSEMBLY	SCALE 1:1
A	01.05.18	NEW ISSUE	

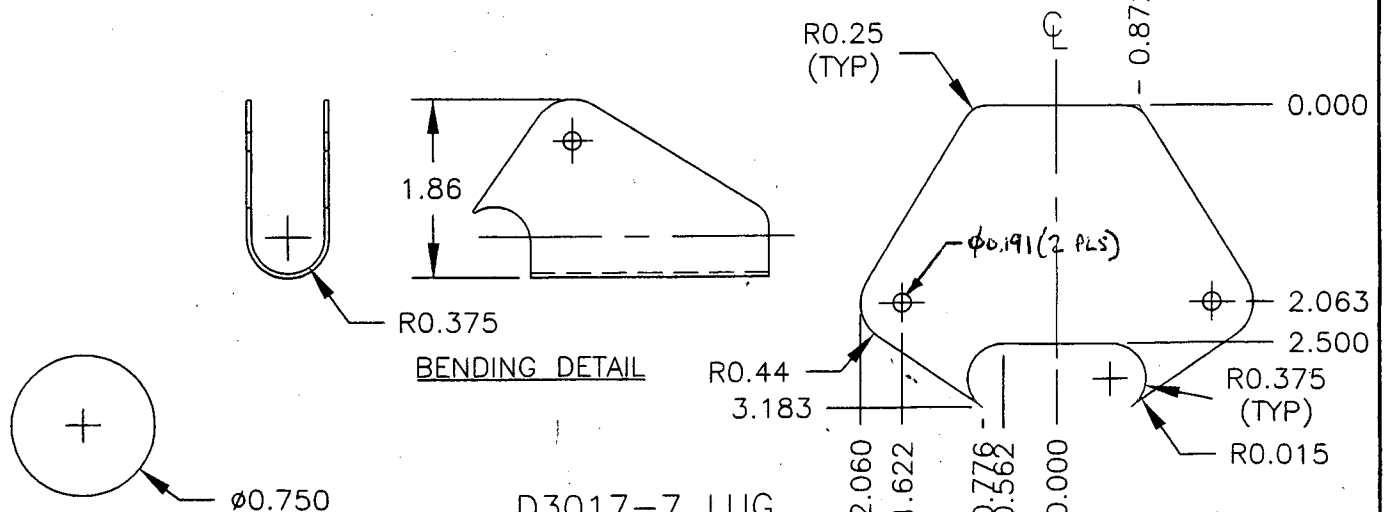
QTY	PART No.	DESCRIPTION	MATERIAL
X	D3017-041	BACK FRAME ASSEMBLY	N/A
1	D3017-1	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
2	D3017-3	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
1	D3017-5	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
3	D3017-7	LUG	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
2	D3017-11	END CAP	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)

#### NOTES

- 1) WELD PER DART QSI 004
- 2) ON SHEET METAL PARTS, BREAK ALL UNMARKED CORNERS 0.020-0.040
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES.
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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FLAT PATTERN  
PART IS SYMMETRIC  
ABOUT CENTERLINE

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# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Feb 14, 2005  
07:34 am

Work Order No : 0022411  
Project Name : D3016-17  
Project For : WK511  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3016-17  
Description : Gusset  
Manufactured : Yes  
Amount Req'd : 20  
Amount Done : 0  
Start Date : 02-11-05  
Est Finish Date : 03-03-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Margin : 0.000%  
Actual Margin : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

